

Work Order ID 132335

132335

Page 1

Thursday, May 07, 2015 10:30:55 AM

Item ID: D4146-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fitting
 Start Date: 5/7/2015 Start Qty: 16.00 *16* Cust Item ID:
 Required Date: 5/28/2015 Req'd Qty: 16.00 *16* Customer:
 Reference:

Approvals: Process Plan: ME Date: 5-5-7 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4146	A

100 0.00 **DAS**
100 25 15/5/29
 Doosan 17
 Doosan Lathe

Memo
 TURN AS PER DWG AND FOLIO FA976
 FOLIO REV: N/A
 DWG REV: A

DEBURR

110 0.00 **DAS**
110 25 15/5/29
 QC 17
 Quality Control

Memo
 QC2- Inspect parts off machine FAI/FAIB

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							DAS 37 9-89 15-05-31
120						17	0		
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: <u>51093</u>	0.00							DAS 28 9-89 JUN 0 1 2015
130						17x			
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							15/6/2
140									
QC	Memo	0.00							
Quality Control									

MS-6-02

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Thursday, May 07, 2015 10:30:53 AM

Page 1

Work Order ID: 132335

132335

Parent Item: D4146-1

D4146-1

Parent Item Name: Fitting

Start Date: 5/7/2015

Required Date: 5/28/2015

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:A NEW ISSUE 10-10-05 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R1.000		Purchased		No		100	f	4.8460	0.1666	3			

M303R1 000

303 Round Bar 1.00

SL 15/5/29

Location

Loc Qty

Loc Code

MAT028

4.846

m124237

1.5

m128496

3.346

132320

2930

DQA: _____ Date: _____

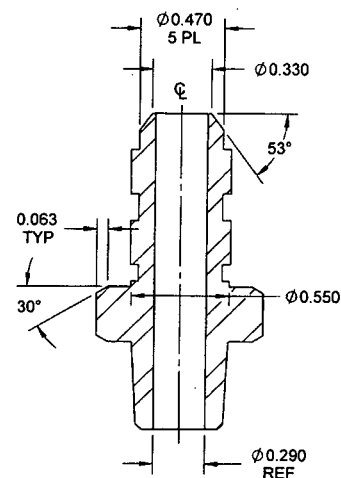
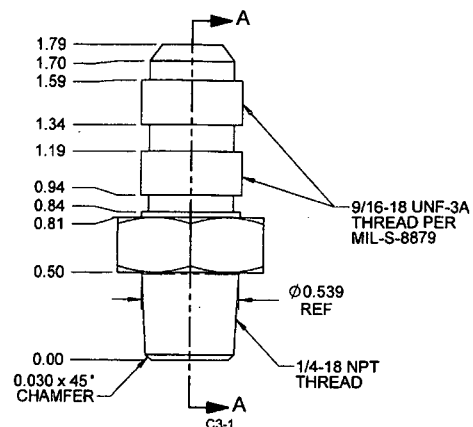


WORK ORDER NON-CONFORMANCE / UPDATE

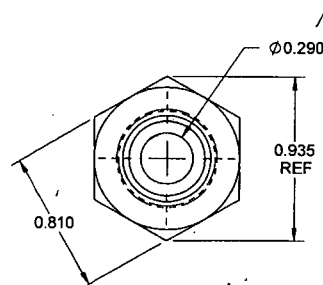
QA Closed: _____ Date: _____

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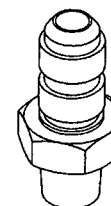
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Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
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OTHER : _____					



SECTION A-A CS-1



D4146-1 FITTING



mf
#132335

RELEASED
2010-09-23
mf

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL HEX BAR OR
AISI 303 STAINLESS STEEL ROUND BAR
DART SPEC. M303H OR M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.11 lbs

A NEW ISSUE		RF 10.09.16	
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	<i>mf</i>		
MFG. APPR.	<i>mf</i>		
APPROVED	<i>mf</i>		
DE APPR.	<i>mf</i>		
DATE	10.09.16		

DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWING NO. D4146	REV. A
TITLE FITTING	SHEET 1 OF 1
	SCALE NTS

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WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

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